

306MF-NP (HIPS)

Description:

High Impact Strength & easy flow

Application:

 TV cabinets, computer parts &
 High flow length moulds etc.

Properties	Test Method	Test Condition	Unit	Typical Value
Physical				
Specific Gravity	ASTM D 792	-	-	1.03
Shrinkage	ASTM D 955	-	%	0.4-0.8
Rheological				
Melt Flow Index	ASTM D 1238 (G)	200 °C / 5 kg	gms / 10min	9.5
Thermal & Optical				
Vicat Softening point	ASTM D 1525	120 °C / Hr, 1 kg	°C	95
Heat Deflection temperature	ASTM D 648	1.82 Mpa	°C	80
Flammability	UL 94	3.2 mm	Rating	HB
Mechanical				
Tensile Strength @ Yield, 3.2 mm	ASTM D 638	50 mm / min	Kg / cm ²	195
Tensile Elongation @ Break, 3.2 mm	ASTM D 638	50 mm / min	%	50
Flexural Strength, 3.2 mm	ASTM D 790	1.3 mm / min	Kg / cm ²	350
Flexural Modulus, 3.2 mm	ASTM D 790	1.3 mm / min	Kg / cm ²	22000
Izod Impact Strength (Notched), 6.4 mm	ASTM D 256	-	Kg.cm / cm	8.5
Rockwell Hardness	ASTM D 785	-	R-Scale	93
Processing Conditions				
Melt Temperature	-	-	°C	180 - 220
Mold Temperature	-	-	°C	45 - 60
Pre-drying temperature	-	-	-	NA

Note:

- The above Typical values in this Product data sheet are intended to serve for material selection purpose only
- Values given should not be interpreted as specification and not be used for part or tool design.
- All properties, except melt flow rate are measured on injection molded specimens and after 48 hours storage at 23°C, 50% relative humidity.
- The design and Characteristics of the product manufactured out of LGPI material are beyond our control & expertise, therefore, LGPI shall not own the responsibility for any consequential damage incurred by the Purchaser.



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Processing guidelines:

- 306MF-NP can be Injection molded under different conditions depending upon the size of the machine, mold size & shape of the components.
- Pre-drying normally not required.

Recommended temperatures:

- Melt Temperature profile: 180-220 °C
- Mould Temperature: 45-60 °C (Optimization of condition gives the best results)

Molding at a very low or very high temperature conditions than required, may cause degradation.

Packing:

Supplied as cylindrical shaped granules in 25 kg PP laminated woven sack bags.

Storage & Handling precautions:

LGPI recommends the storage of Polystyrene in dust free environment, dry & cool place in a shade an avoid direct exposure to sunlight

Product Safety:

Processing may release fumes, which may be irritating. Sufficient ventilation should be provided in the processing area. If it causes eye discomfort, use a full-face respirator.

Handling & fabrication of plastic resin may result in the generation of dust. Dust resulting from sawing, filing & sanding of plastic parts in post molding operations may cause irritation to eyes. In dusty atmospheres, use an approved dust respirator.

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